

Date: Monday, 7/16/2007 2:45:31 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	FLOAT SKIDTUBE		
Job Number	33556		Part Number	D412742013		
Estimate Number	10366		Drawing Number	N/A		
P.O. Number	N/A		Project Number	N/A		
This Issue	7/16/2007	S.O. No. N/A	Drawing Revision	N/A		
Prsht Rev.	NC	Type	LANDING GEAR	Material	N/A	
First Issue	N/A			Due Date	7/30/2007	Qty: 1 Um: Each
Previous Run	33555					
Written By	<i>JK</i> 07.07.17					
Checked & Approved By						
Comment	Est Rev: A 05.10.13 New Issue KJ/JLM Est Rev:B 06-06-08 As per DS19336 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	DC	DOCUMENT CONTROL			
		Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D412-742-013 CHG003			KJ 07-07-26
2.0	33556A	FLOAT SKID ASSEMBLY			
		Comment: Sub-Component FLOAT SKID ASSEMBLY D412-742-043 B 33556A			
3.0	D2571	Saddle, Fwd, Out			
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)			
		Pick:			
		Qty Part Number	Description	Batch	
		1 D2571	Saddle Fwd Outside	1531647	✓ SP
4.0	D2572	Saddle, Fwd, In			
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)			
		Pick:			
		Qty Part Number	Description	Batch	
		1 D2572	Saddle Fwd Inside	1531714	✓ SP
5.0	D2573	Saddle, Aft, Out			
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)			
		Pick:			
		Qty Part Number	Description	Batch	
		1 D2573	Saddle Aft Outside	153042	✓ 7/7/2015 SP

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FLOAT SKIDTUBE
Job Number: 33556		Part Number: D412742013
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	D2574	Saddle, Aft, In 
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2574 Saddle Aft Outside <i>1331718</i> ✓ <i>SG</i>	
7.0	D2747	Set Screw 
		
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 4 D2747 Bolt <i>1331300</i> ✓ <i>SG</i>	
8.0	D2876	Saddle Spacer 
		
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2876 Saddle Spacer <i>1331227</i> ✓ <i>SG</i>	
9.0	D2877	Saddle Spacer 
		
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2877 Saddle Spacer <i>1330655</i> ✓ <i>SG</i>	
10.0	D34031	Bushing 
		
	Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s) Pick: Qty Part Number Description Batch 16 D3403-1 Bushing <i>1332888</i> ✓ <i>SG</i>	
11.0	D34033	Bushing 
		
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 8 D3403-3 Bushing <i>1332889</i> ✓ <i>7/7/24 SG</i>	

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33556

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 D3405041 Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3405-041 GHW Lug M32890 ✓ S9

13.0 D3405043 Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3405-043 GHW Lug M32891 ✓ S9

14.0 AN4C6A Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
16 AN4C6A Bolt M104936 ✓ S9

15.0 AN4C46A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN4C46A Bolt M19529 ✓ S9

16.0 AN4C52A BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 AN4C52A Bolt M100340 ✓ S9

17.0 AN6C12A BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 AN6C12A Bolt M104289 ✓ 7/17/24 S9

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33556

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation:

Description :

18.0 AN960C416L WASHER



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

47 32 AN960C416L

Washer

M104925 ✓

Sd

19.0 AN960C616L WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

47 8 AN960C616L

Washer

M18822 ✓

Sd

20.0 AN960C716L WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 AN960C716L

Washer

M1049093 ✓

Sd
M13542

21.0 MS210434 Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

29 MS21043-4Nut

M104936

✓

Sd

22.0 NAS1515H4L Inventory



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

32 NAS1515H4L

Washer

M104956 ✓

7/7/2018

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33556

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation:

Description :

23.0 NAS1515H6L Inventory



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 NAS1515H6L Washer M18918 ✓ SP

24.0 NAS1515H7L Inventory



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
16 NAS1515H7L Washer M100727 ✓ SP

25.0 D3407041 Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3407-041 TOW RING B30394 ✓ SP

26.0 D34173 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3417-3 WASHER 1533519 ✓ SP

27.0 D34561 washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3456-1 WASHER 1533276 ✓ SP

28.0 AN4C7A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M101427 ✓ 7/7/24 SP

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33556

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation:

Description :

29.0 QC4

INSPECT 100% KITS FOR COMPLETENESS

Ex 07/08/01



Comment: INSPECT 100% KITS FOR COMPLETENESS

30.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location: *REV:0*

07/08/01 *SP*

31.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/07 *①*

Job Completion



07/08/07

FLOAT Skid Ass: B33556A

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLOAT SKID ASSEMBLY		
Job Number	: 33556A		Part Number	: D412742043		
Estimate Number	: 10756		Drawing Number	: D3391 REV F		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 7/16/2007 S.O. No. : N/A		Drawing Revision	: F		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 7/30/2007 Qty: 1 Um: Each		
Previous Run	: 33555A					
Written By						
Checked & Approved By						
Comment	: Est-Rev A 05.10.13 New Issue		KJ/JLM			
	Est Rev B 06.02.13 ECN 773 dwg @ rev.D		EC			
	Est Rev:C 07-05-28 As per Rev F		JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL If D412-742-043 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-043 CHG003 <i>N/A</i>		
2.0	D3391023	Mid Tube Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) pick: Qty Part Number Description Batch 1 D3391-023 Mid Tube Assembly <i>B31312</i> <i>SD</i>		
3.0	D3391025	Aft Tube Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) pick: Qty Part Number Description Batch 1 D3391-025 Aft Tube Assembly <i>B31859</i> <i>SD</i>		
4.0	D35641	WEARSHOE
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: <i>B31312</i> <i>SD 07-07-24 ①</i>		

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Customer: CU-DAR001 Dart Helicopters Services

Kim Johnston

Process Sheet

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33556A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D35643 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 33641 B33764

ML 01 01 28

6.0 D35645 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 32738

ML 01 01 28

7.0 D35661 GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: 33453

ML 01 01 28

8.0 D35665 GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 33483

ML 01 01 28

9.0 AN3C4A BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

Batch: 104955

ML 01 01 28

10.0 AN3C6A BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Batch: 103693

ML 01 01 28

11.0 AN3C7A BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Batch: 103608

ML 01 01 28

Date: Monday, 7/16/2007 2:45:46 PM
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Process Sheet

Customer: 'CU-DAR001 Dart Helicopters Services		Drawing Name: FLOAT SKID ASSEMBLY
Job Number: 33556A		Part Number: D412742043
Job Number:		
Seq. #:	Machine Or Operation:	Description :
12.0	AN960C10L	washer
		
Comment: Qty.: 44.0000 Each(s)/Unit		Total : 44.0000 Each(s)
A/R washer		ML 010728
13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comment: HAND FINISHING RESOURCE #1		
1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391		
A/R LPS-3 <u>M105085</u>		
2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.		
A/R Sikaflex-241/-291 <u>M104989</u>		
Expiry date: <u>01/2008</u> > <u>M 010728</u>		
3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".		
Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.		
A/R LPS Procyon <u>104251</u>		
A/R Sikaflex-241/-291 <u>104282</u> > <u>M 010728</u>		
Expiry date: <u>01/2008</u> > <u>M 010728</u>		
4-Remove "T" pins once sikaflex is dry.		
5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.		
14.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP		
15.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1		
Identify and pack for shipping as per PPP D412-742-043		
Location: <u>PPP 33556</u> > <u>BB 07/08/010</u>		
PPP Rev: <u>33556</u> > <u>BB 07/08/010</u>		

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
070801	7.0						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: M Date: 07-08-15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070801	7.0	Rubber Gasket was torn, so scrap + Replace	<u>08/02</u>	Replaced Gasket with a good one B 33458	<u>M.A.</u> <u>07/08/01</u>	<u>MA-30</u>	<u>08/02</u>	<u>07/07/01</u>

NOTE: Date & initial all entries

Date: Monday, 7/16/2007 2:45:46 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33556A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation:

Description:

16.0 QC21

FINAL INSPECTION/W/O RELEASE



(1)

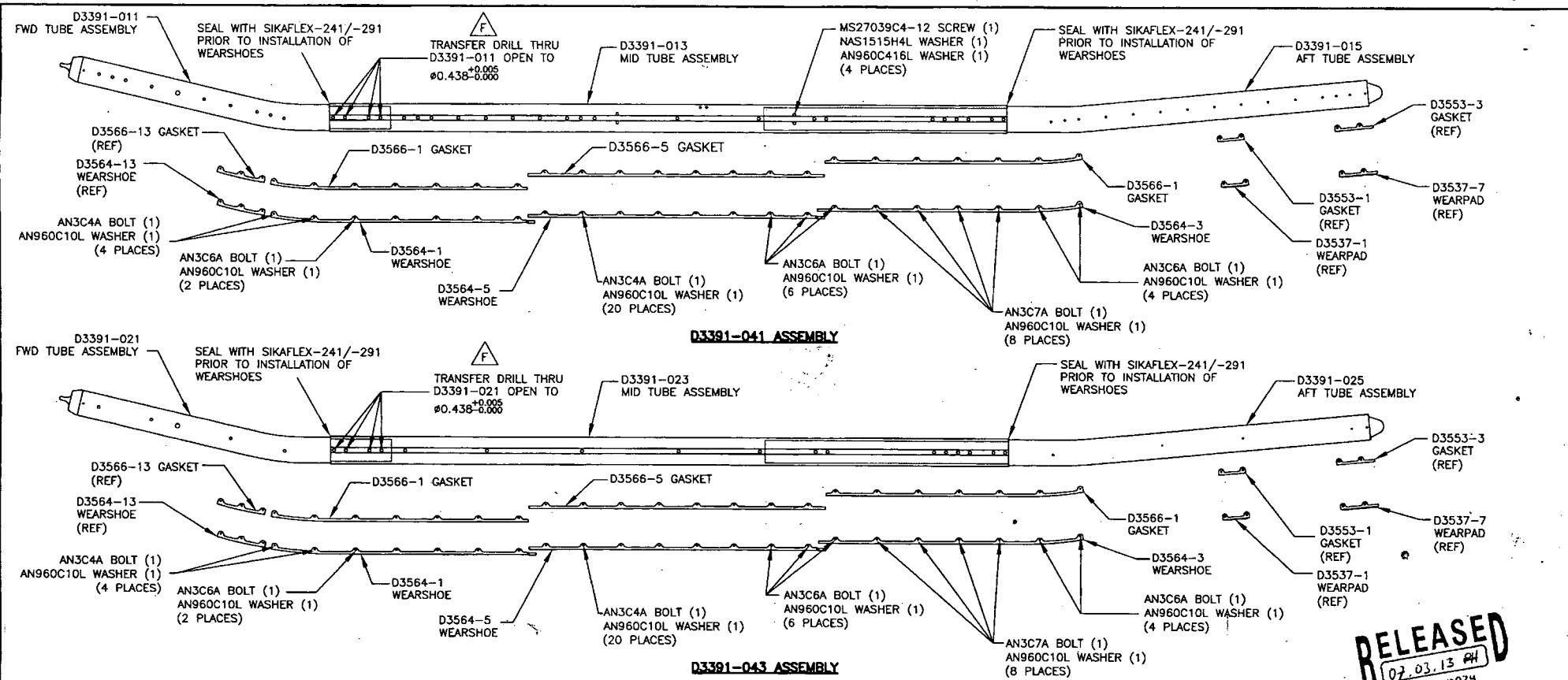
Comment: FINAL INSPECTION/W/O RELEASE

D728109

Job Completion



6/16/07



RELEASER
07.03.13 PH
per E.CN #934

D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3391-041	FLOAT SKIDTUBE ASSEMBLY
	X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C5A	BOLT
3	3	AN3C6A	BOLT
44	44	AN960510L	WASHER
4		MS70709C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN9605146L	WASHER

GENERAL NOTES

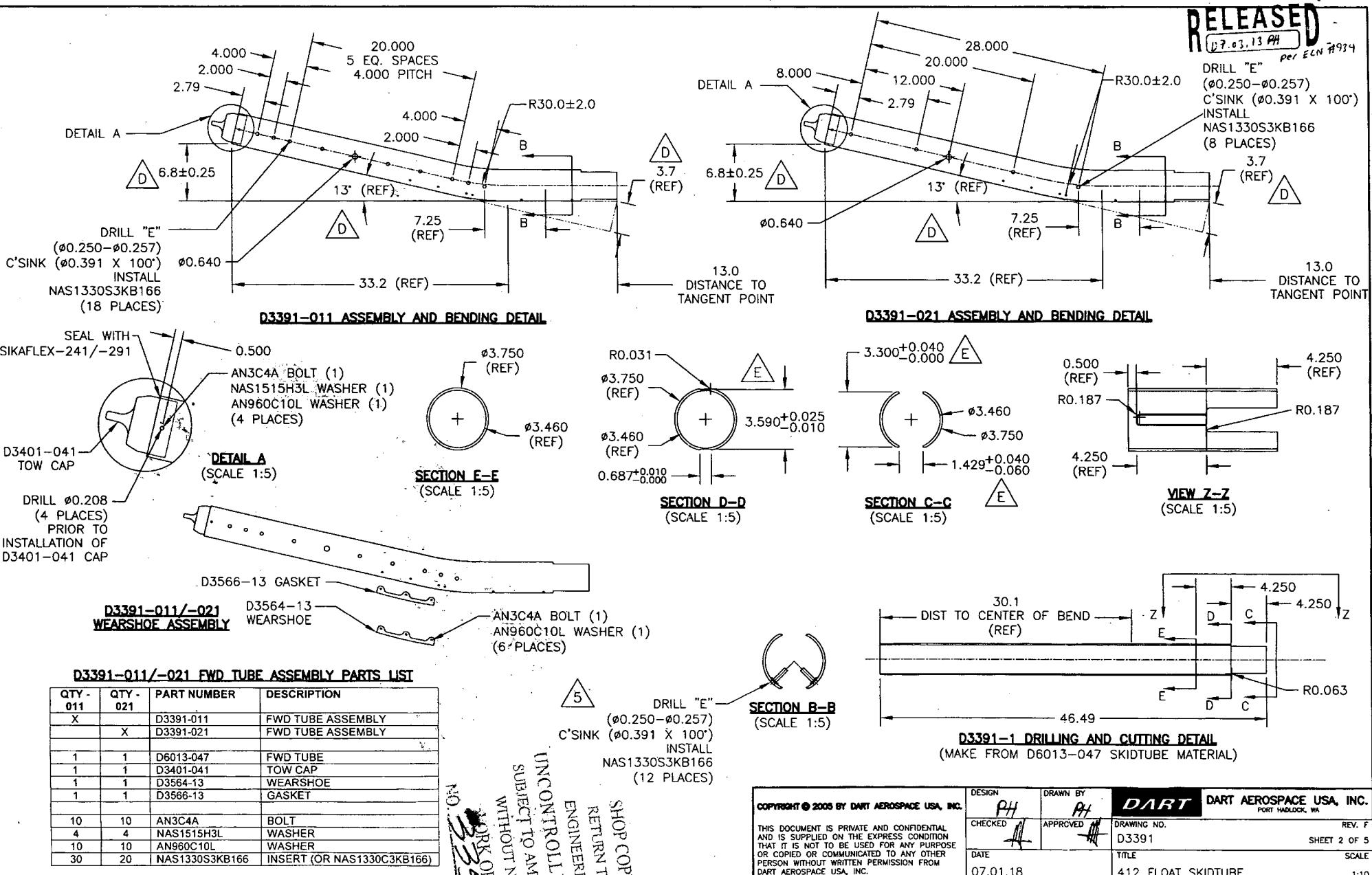
- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
. POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (.00.250-.00.257) FOR WEARSHOE INSERTS. C'SINE .0391/.00.425 x 100° AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

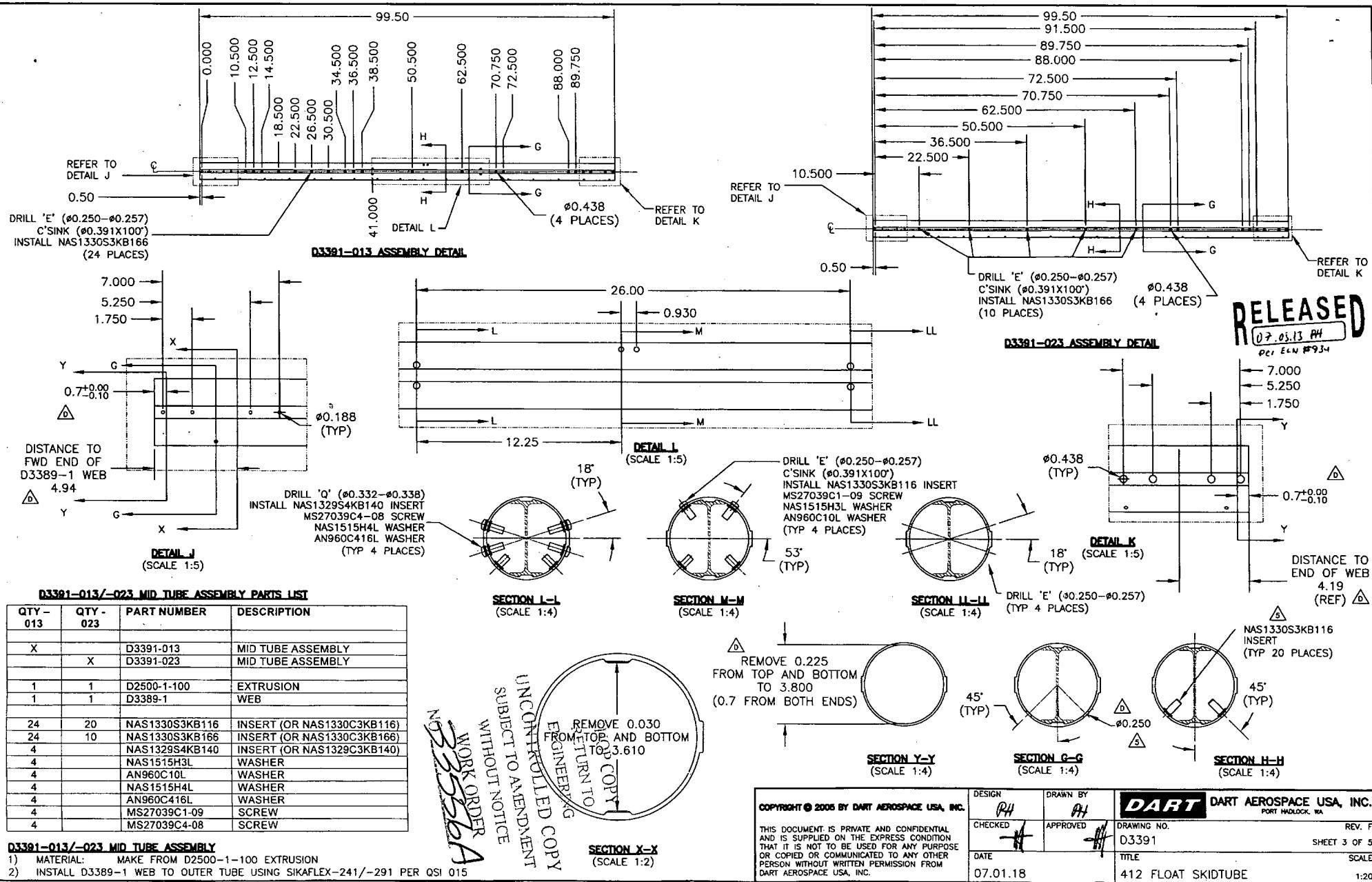
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N 33536 A

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		DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE	SCALE AS

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RELEASED
07.03.13 AM
per ECN A934





D3391-013/-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015

11. *What is the primary purpose of the following statement?*

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PORT HADLOCK, WA

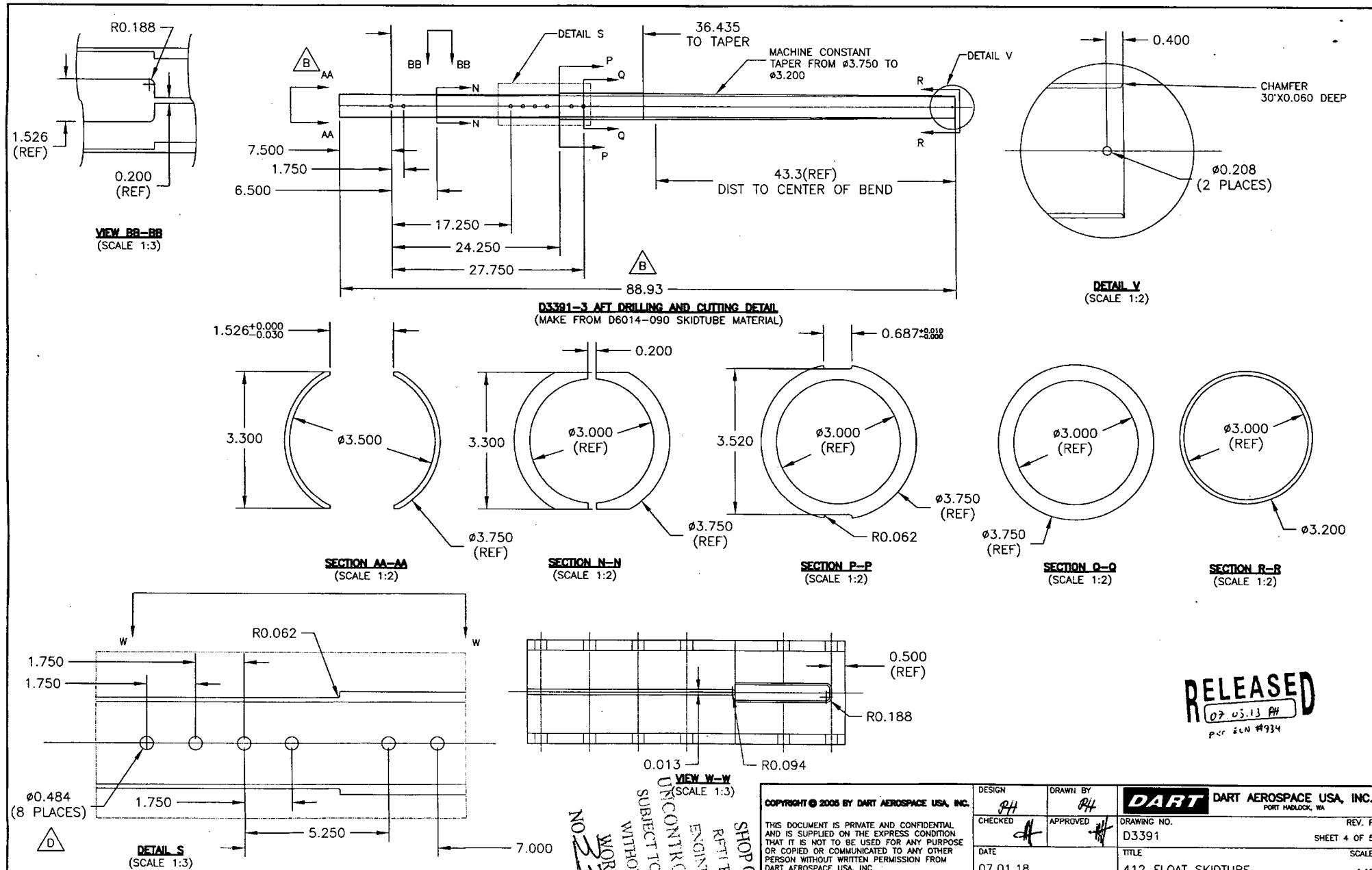
REV. F

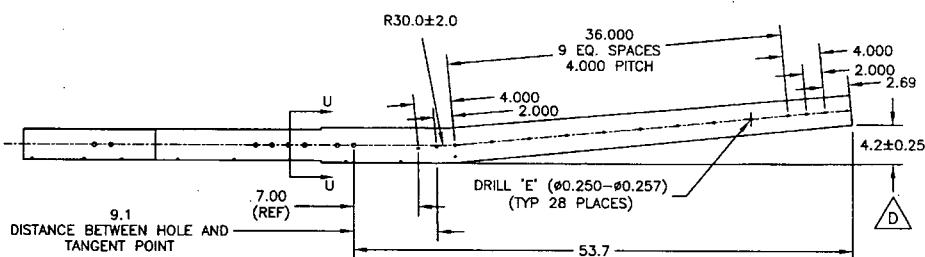
SHEET 3 OF 5

Digitized by srujanika@gmail.com

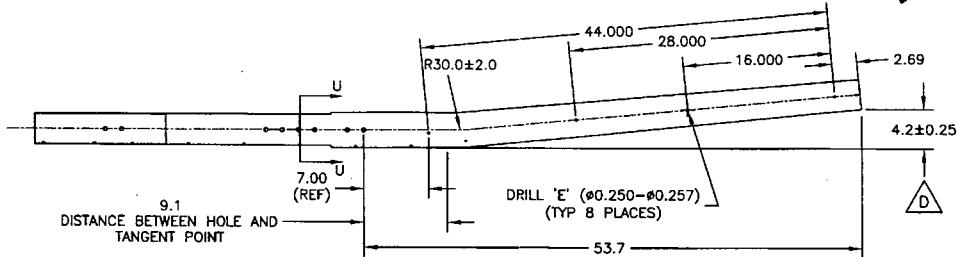
SCALE

KIDTUBE 1:20

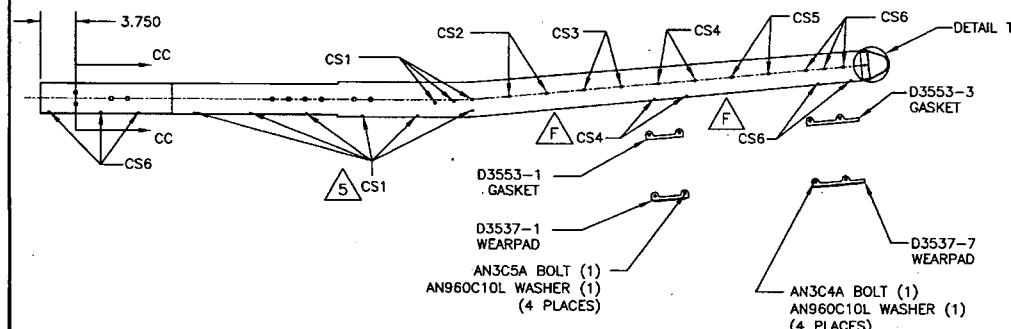




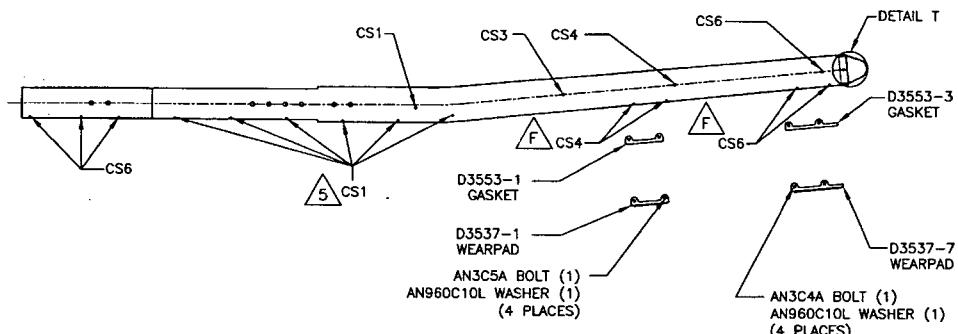
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)



D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER

UNCONTROLLED COPY
SECTION CC-CC
SCALE 1:3
18° (TYP)
SECTION II-II
SCALE 1:3
5
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
N33536A

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3391	SHEET 5 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE	

RELEASED
07.03.13 PH
per ECN #934

